

# Work Order ID 73704



Page 1

Tuesday, September 13, 2011 2:45:58 PM

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Item Name: Skidtube Installation

Stop



Start Date: 9/13/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3507

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

8.10/26

for MLS 11-10-26

73704

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Cut Aft end as per dwg D3507								
	2-Deburr ends								
	3-Drill Aft & Fwd Cap holes using DT8678 & DT8901								
	4-Locate DT8870 & Drill Ground wire hole on top of Tube.								
	6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES****								
	7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.								
	8-Open six rear wearplate holes using DT8892. Open holes to 0.297"								
	9-Open Aft & Fwd Cap holes using .208" drill.								
	10-Bore out aft end of tube as per Dwg D3507 & Detail "B".								
	11-Open ground wire hole .297" section E-E								
	12- Section G-G holes must be laid out manually, open to #30.								
	13-Deburr holes.								

11-10-19

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

H

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

C

SAD 11-10-12

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

DP

11-10-12

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Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

0.00



Skidtubes

0.00

Skidtubes

Memo

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.  
and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 &amp; QSI 015

A/R 241 Sike Flex Batch: M118393

Exp Date: 12-5-5

start time: 4PM

end time: 11/10/20 10:30

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C &amp; D-D.

A/R AL ROD Batch: M117884

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&amp;B

8-Deburr Rivet holes.

DP 11-10-19

SAD 11-10-20

SAD 11-10-20

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00							
190  Skidtubes Skidtubes	Skidtubes  Memo 1-Rivet D3506-1/-3 as per Dwg D3507.	0.00 0.00						11/10/21	
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							

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Required Date: 9/23/2011 Req'd Qty: 1.00

Customer:

Reference:

Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210 Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 d H u/10/24

220 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:15  
320°F  
10:45

IXCM-L 11/10/24

230 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 d H u/10/24

W/O:		WORK ORDER CHANGES					
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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1 0 11/10/24

1- Install Wearplate &amp; Ground Wire inserts as per Dwg D3507.

1- Inspect for Foreign objects

2- Install Fwd &amp; Aft caps as per Dwg D3507 And Detail "A" &amp; "B"

A/R 241 Sika Flex Batch: M118393  
Exp Date: 12/053- Install Wearplates as per Dwg D3507,  
Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube  
Do not Install Screws where indicated on Dwg (Note #6)A/R 241 Sika Flex Batch: M118393  
Exp Date: 12/05

4- assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M1103485- Wing Walk as per Dwg D3507 and QSI 005 4.4  
Batch: M110988

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
280	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
290	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

8 ul10/26

Sp 11-10-26

8 ul10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011 Location: _____ PPP Rev: _____								
310		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

Pull 10/27 (1)

11/10/28

ME

11-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Tuesday, September 13, 2011 2:46:19 PM

Page 1

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00


Comments: IPP Rev:A 06-06-21 New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

ALS7-1032-130		Purchased	No				Each	1,117.000		38			
													
Insert													


Location	Loc Qty	Loc Code
ST282	1117	M118966
117717	899	
118386	218	

X38

D3507-1-BENT		Manufactured	No			120	Each	1.0000	1	1			
													
Skidtube Assembly EC135													

Location	Loc Qty	Loc Code
LG 72564	1	
71201	1	

① DD 11-10-19

D3504-1		Manufactured	No			170	Each	13.0000	2	2			
													
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG	11	
71130	11	
LG001	2	
53742	2	

2

869/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each

17.0000 1 1



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

17

53743

17

D3504-5 Manufactured No

170 Each

11.0000 2 2



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

11

71226

11

D3505-1 Manufactured No

170 Each

0.0000 1 1



Web

75211

D3506-1 Manufactured No

190 Each

11.0000 4 4



Doubler

Location

Loc Qty

Loc Code

ST063

11

51789

11

D3506-3 Manufactured No

190 Each

69.0000 2 2



Doubler

Location

Loc Qty

Loc Code

ST063

69

51790

69

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Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3

Purchased

No

190

Each

2,498.000

12

12



Rivet



12 12 11/10/21

Location

Loc Qty

Loc Code

ST321

2498

114538

2498

ALS4-1032-225

Purchased

No

260

Each

1,915.000

1

1



Insert



1 11/10/21

Location

Loc Qty

Loc Code

ST282

1915

110768

62

117717

9

118386

860

118696

984

AN3C4A

Purchased

No

260

Each

2,912.000

31

31



BOLT



31 11/10/21

Location

Loc Qty

Loc Code

ST350

2912

117313

2

117688

5

117795

1

117872

22

118012

20

118112

40

118451

1000

118628

322

118706

500

118838

1000

x31

W/O:		WORK ORDER CHANGES					
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Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00


Required Qty: 1.00

AN3C5A Purchased No 260 Each 1,142.000 2 2  
  
 Bolt

Location	Loc Qty	Loc Code
FP-A	7	1111343
115835	7	
ST350	1135	
116419	28	
116549	23	
117343	360	
117764	222	
117872	2	
118451	500	

1110124


x2

AN526C1032R10 Purchased No 260 Each 281.0000 2 2  
  
 Screw

Location	Loc Qty	Loc Code
FP-B	91	
108062	91	
ST327	100	
114494	100	
ST328	90	
110049	90	

1110124

x2

AN960C10L NAS1149C0332 Purchased No 260 Each 0.0000 33 33  
  
 washer

1118354 (x33) 1110124

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 2:46:19 PM

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D2965

Manufactured No

260

Each

44.0000

1

1



Cap, 105 Skidtube



22 11/10/21

Location

Loc Qty

Loc Code

FP006

44

71371

44

X1

D2965-3

Manufactured No

260

Each

4.0000

1

1



Cap



22 11/10/21

Location

Loc Qty

Loc Code

FP005

4

50560

1

71300

3

X1

D3492-1

Manufactured No

260

Each

32.0000

4

4



Plug



22 11/10/21

Location

Loc Qty

Loc Code

FP

32

69531

8

71836

24

1373402

X1

D3492-3

Manufactured No

260

Each

133.0000

4

4



Plug



22 11/10/21

Location

Loc Qty

Loc Code

FP

133

71838

100

72126

33

X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 2:46:19 PM

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3492-7	Manufactured	No	260	Each	14.0000	2	2
							<u>HL 11/10/24</u>
Plug							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FA-A	14	
<u>71881</u>	14	

D3508-1	Manufactured	No	260	Each	15.0000	1	1
							<u>HL 11/10/24</u>
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP016	15	
<u>61020</u>	3	
<u>72933</u>	12	

D3508-3	Manufactured	No	260	Each	9.0000	1	1
							<u>HL 11/10/24</u>
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP021	1	
38527	1	
FP21	8	
<u>72169</u>	8	

D3508-5	Manufactured	No	260	Each	21.0000	1	1
							<u>HL 11/10/24</u>
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP021	21	
<u>71688</u>	9	
72416	12	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 2:46:19 PM

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-7 Manufactured No

260 Each

8.0000

1

1



Wearplate

Location

Loc Qty

Loc Code

FP020

7

72932

7

FP021

1

67739

1

D3558-1 Manufactured No

260 Each

3.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

3

50925

3

D3558-3 Manufactured No

260 Each

7.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

7

71651

1

72170

6

D3558-5 Manufactured No

260 Each

5.0000

1

1



Gasket

Location

Loc Qty

Loc Code

FP014

5

67485

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

Page 8

Tuesday, September 13, 2011 2:46:20 PM

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-7  
Gasket  
Manufactured No

260 Each

5.0000

1

1



all 9/10/2011

Location

Loc Qty

Loc Code

FP014

5

67162

5

21

NAS1611-007  
O-RING  
Purchased No

260 Each

276.0000

2

2



all 9/10/2011

Location

Loc Qty

Loc Code

FP-A

276

103697

276

22

NAS1611-010  
O-RING  
Purchased No

260 Each

202.0000

4

4



all 9/10/2011

Location

Loc Qty

Loc Code

FP

185

117460

8

118077

1

118612

176

FP-A

17

110915

14

115589

3

24

Tuesday, September 13, 2011 2:46:20 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 9

Tuesday, September 13, 2011 2:46:20 PM

Work Order ID: 73704

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

260

Each

188.0000

4

4



O-RING



xl 11/10/20

## Location

## Loc Qty

## Loc Code

FP

55

117291

2

117887

53

FP-A

133

116582

5

118384

128

xl

AN3C4A

Purchased

No

280

Each

2,912.000

8

8



BOLT



SP

## Location

## Loc Qty

## Loc Code

ST350

2912

117313

2

117688

5

117795

1

117872

22

118012

20

118112

40

118451

1000

118628

322

118706

500

118838

1000

8x

AN960C10L

NAS1149C0332

Purchased

No

280

Each

0.0000

8

8



washer



m 119124

SP 11-10-26.

Tuesday, September 13, 2011 2:46:20 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, September 13, 2011 2:46:20 PM

Work Order ID: 73704



Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 9/13/2011

Required Date: 9/23/2011

Start Qty: 1.00

Required Qty: 1.00

D3512-1

Manufactured No

280

Each

1.0000

2

2



Wearplate



B 73955 2x

80 11-10-26.

Location

Loc Qty

Loc Code

ST500

1

71795

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D3492-XX PLUG  
(SEE TABLE)

NAS1611 O-RING  
(SEE TABLE)

### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73704

*11-09-13*

**RELEASED**  
2011-05-30  
*JP*

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	08.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>J.F.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AJS</i>	D3492	SHEET 1 OF 2
APPROVED	<i>AJS</i>	TITLE	SCALE
DE APPR.	<i>AJS</i>	PLUG	2:1
DATE	11.05.24	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

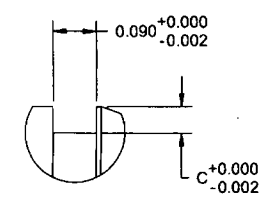
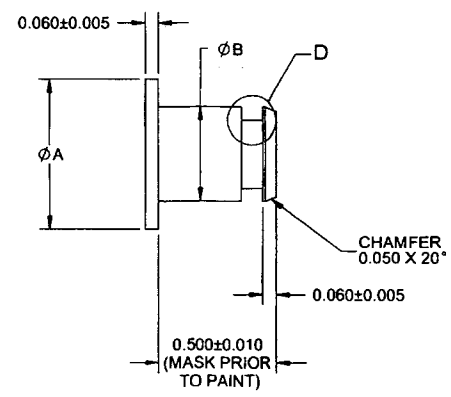
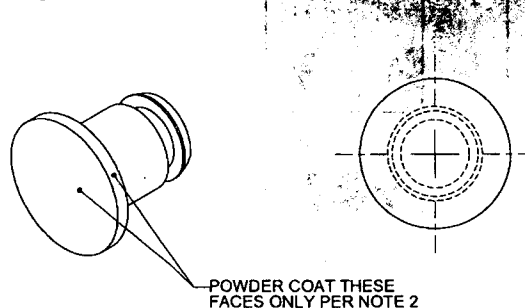
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



CHANGES



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

- NOTES:
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

73704

RELEASED  
2011-05-30

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JES	D3492	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	4:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

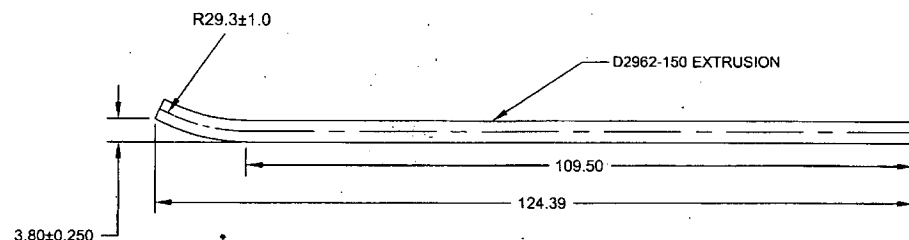
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

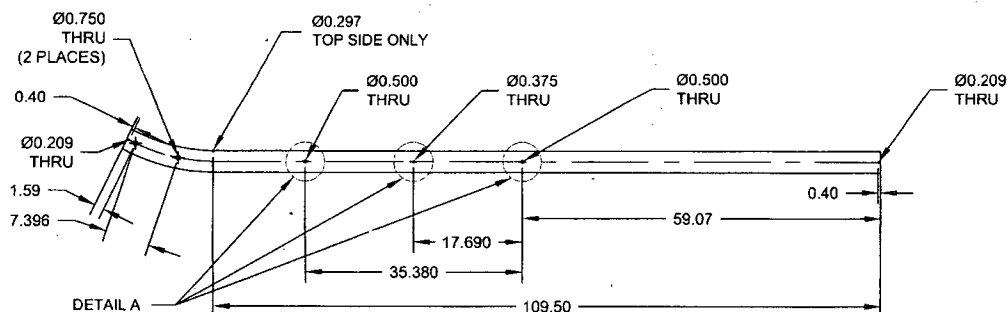
8 7 6 5 4 3 2 1

D



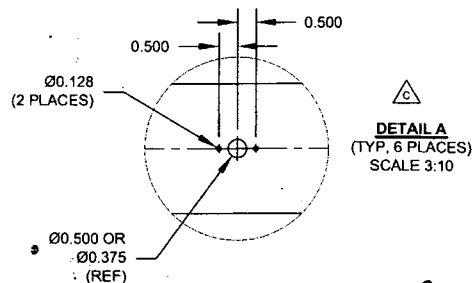
D3507-1 BENDING/CUTTING DETAIL

C



D3507-1 DRILLING DETAIL

B



A

8 7 6 5 4 3 2 1

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3506-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

GENERAL NOTES:

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	PC		
CHECKED	BA	DRAWING NO.	REV. C
MFG. APPR.	ED	D3507	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	ST	EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

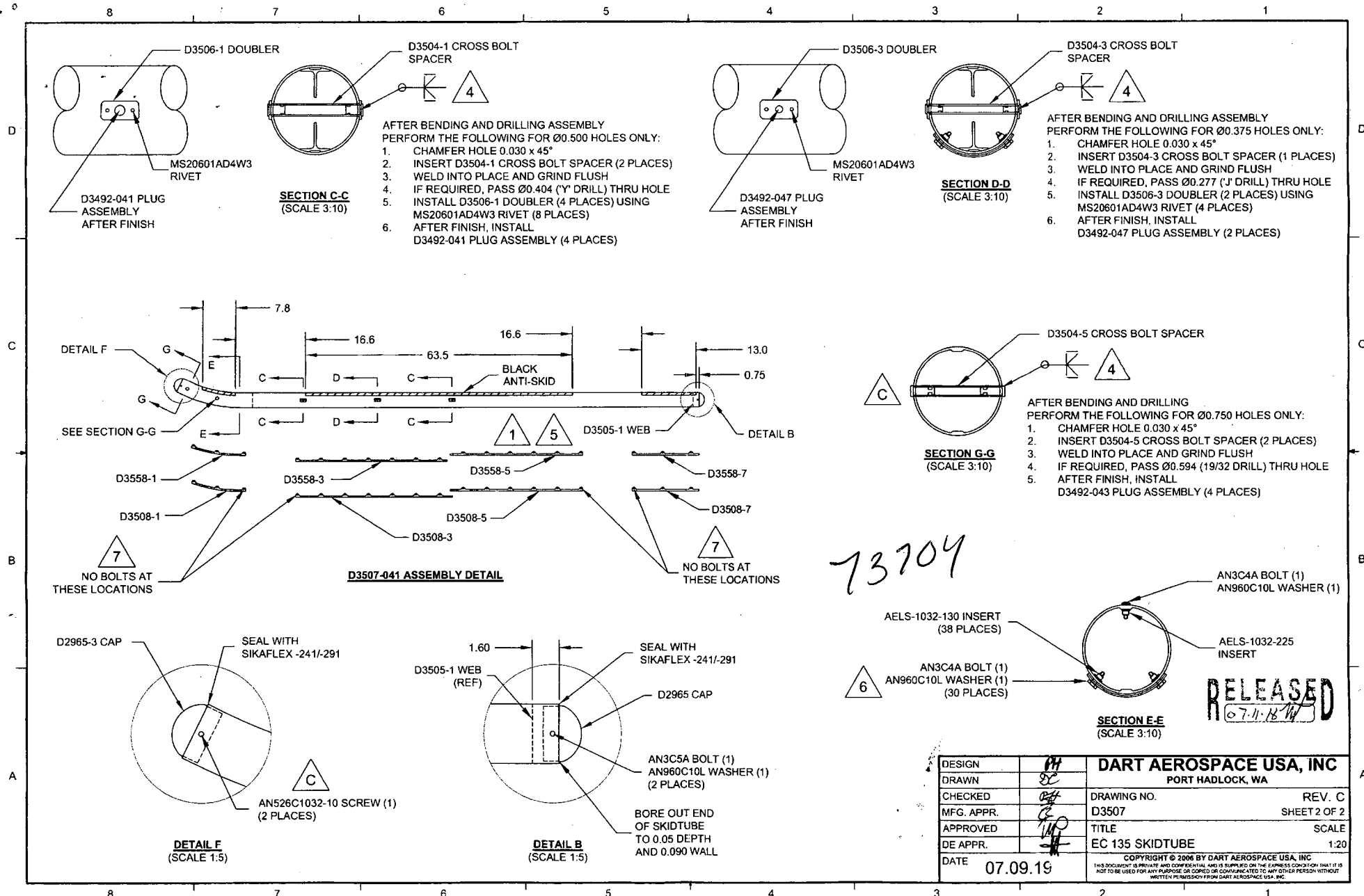
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 257

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: B666P  
Part number: D135-751-011  
Description: 135  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☐ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Cunn Date of Test Coupon 11-06-22

Welder Barclay Elliot Date of Test Coupon 11-06-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld